

U.S. Application No. 10/669,198

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This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1. (Previously Presented) A method of producing a liquid container closure comprising the acts of providing a cap having an interior surface defining an interior region, an exterior surface lying outside the interior region, and at least one hole extending from the interior surface to the exterior surface and moving a plastics material through the at least one hole to create a monolithic compliant member having a cap liner located on the interior surface of the cap and adapted to mate with a neck of a beverage container received in the interior region of the cap and a grip portion on the exterior surface of the cap

wherein the moving act comprises applying the plastics material to the interior surface of the cap and then compressing the plastics material to form the cap liner in the interior region of the cap and form the grip portion of the exterior surface on the cap.

2. (Cancelled)

3. (Previously Presented) A method of producing a liquid container closure comprising the acts of providing a cap having an interior surface defining an interior region, an exterior surface lying outside the interior region, and at least one hole extending from the interior surface to the exterior surface and moving a plastics material through the at least one hole to create a monolithic compliant member having a cap liner located on the interior surface of the cap and adapted to mate with a neck of a beverage container received in the interior region of the cap and a grip portion on the exterior surface of the cap,

wherein the moving act comprises applying the plastics material to the interior surface of the cap and then compressing the plastics material to form the cap liner in the interior region of the cap and form the grip portion of the exterior surface on the cap, and

wherein the applying act comprises extruding a plastics material onto the interior surface of the cap, determining the weight of the plastics material being extruded onto the interior surface of the cap, and ceasing the extruding step once the weight of plastics material extruded onto the interior surface reaches a predetermined weight detected during the determining step.

4. (Previously Presented) The method of claim 1, wherein the cap includes a top wall and an annular skirt cooperating with the top wall to define the interior region and the plastics material is applied to a portion of the interior surface located on the top wall.

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5. (Previously Presented) The method of claim 1, wherein the cap is formed at a first station and the method further comprises, in series, transporting the cap from the first station to a second station, carrying out the applying step at the second station, transporting the cap and the plastics material on the interior surface of the cap to a third station, and carrying out the compressing step at the third station.

6. (Original) The method of claim 5, wherein the applying act comprises extruding a plastics material onto the interior surface of the cap, determining the weight of the plastics material being extruded onto the interior surface of the cap, and ceasing the extruding step once the weight of plastics material extruded onto the interior surface reaches a predetermined weight detected during the determining step.

7. (Currently Amended) A method of producing a liquid container closure comprising providing a cap having an interior surface defining an interior region, an exterior surface lying outside the interior region and an opening connecting the interior and exterior surfaces, and compressing a plastics material located in the interior region and forcing some plastics material through the opening to create a monolithic compliant member having a cap liner located on the interior surface of the cap and adapted to mate with a neck of a beverage container received in the interior region of the cap and a grip portion on the exterior surface of the cap.

8. (Previously Presented) The method of claim 7, wherein the compressing act includes the steps of moving a punch into the interior region of the cap to form the cap liner on the interior surface and to move plastics material through the opening formed in the cap and collecting plastics material moved through the opening to establish the grip portion on the exterior surface of the cap.

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9. (Previously Presented) A method of producing a liquid container closure comprising providing a cap having an interior surface defining an interior region and an exterior surface lying outside the interior region and compressing a plastics material located in the interior region to create a monolithic compliant member having a cap liner located on the interior surface of the cap and adapted to mate with a neck of a beverage container received in the interior region of the cap and a grip portion on the exterior surface of the cap,

wherein the compressing act includes the steps of moving a punch into the interior region of the cap to form the cap liner on the interior surface and to move plastics material through an opening formed in the cap and collecting plastics material moved through the opening to establish the grip portion on the exterior surface of the cap, and

further comprising the step of applying the plastics material to the interior surface before the moving and collecting steps and wherein the applying step includes the steps of extruding a plastics material onto the interior surface of the cap, determining the weight of the plastics material being extruded onto the interior surface of the cap, and ceasing the extruding step once the weight of plastics material extruded onto the interior surface reaches a predetermined weight detected during the determining step.

10. (Original) The method of claim 9, wherein the cap includes a top wall and an annular skirt cooperating with the top wall to define the interior region and the plastics material is applied to a portion of the interior surface located on the top wall.

11. (Original) The method of claim 9, wherein the cap is formed at a first station and the method further comprises the steps of, in series, transporting the cap from the first station to a second station, carrying out the applying step at the second station, transporting the cap and the plastics material on the interior surface of the cap to a third station, and carrying out the moving step at the third station.

12. (Original) The method of claim 7, further comprising the step of applying the plastics material to the interior surface before the compressing step and wherein the applying step includes the steps of extruding a plastics material onto the interior surface of the cap, determining the weight of the plastics material being extruded onto the interior surface of the cap, and ceasing the extruding step once the weight of plastics material extruded onto the interior surface reaches a predetermined weight detected during the determining step.

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13. (Previously Presented) A method of producing a liquid container closure comprising the acts of

providing a cap having an interior surface defining an interior region, an exterior surface lying outside the interior region, and holes extending from the interior surface to the exterior surface and

compressing a plastics material on the cap interior surface through the holes to create a monolithic compliant member having a cap liner located on the interior surface of the cap and adapted to mate with a neck of a beverage container received in the interior region of the cap and a grip portion on the exterior surface of the cap.

14. (Previously Presented) The method of claim 13, wherein there are at least ten holes in the cap between the interior surface and exterior surface and the cap liner and the grip portion are joined through these holes.

15. (Previously Presented) The method of claim 13, wherein there are at least four holes in the cap between the interior surface and exterior surface and the cap liner and the grip portion are joined through these holes.

16. (Previously Presented) A method of producing a liquid container closure comprising the acts of

providing a cap having an interior surface defining an interior region, an exterior surface lying outside the interior region, and holes extending from the interior surface to the exterior surface and

moving a plastics material through the holes to create a monolithic compliant member having a cap liner located on the interior surface of the cap and adapted to mate with a neck of a beverage container received in the interior region of the cap and a grip portion on the exterior surface of the cap,

wherein a pellet of a predetermined amount is placed on the interior surface and the pellet is compressed during the moving step forcing some plastics material through at least some of the holes to create the cap liner and the grip portion.